

SC-55 Cored

TYPE : Rutile

AWS A5.29 / ASME SFA5.29 E81T1-GC
JIS Z3313 T55 2 T1-1 C A-U H10

Applications

All position welding for construction machinery, bridge structures and storage tanks.

Characteristics on Usage

SC-55 Cored is a titania type flux cored wire applicable for all-position welding by 100% CO₂ shielding gas has good weldability and low spatter levels and good bead appearance. Slag covering is uniform and easy to remove.

Notes on Usage

- ① Proper preheating (50~150°C)(122~302°F) and inter-pass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② Use 100% CO₂ gas.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.45	1.40	0.012	0.006

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
560 (81,200)	610 (88,500)	28.5	-20 (-4)	80 (59)

Approval

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.045	.052	1/16	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F	120~300	150~350	180~380
HF	120~300	150~350	180~340
V-up & OH	120~260	150~270	180~280
V-Down	200~300	220~320	250~350